

5 forming said stile members and said rail members with flat, inwardly directed attachment flanges, positioning said transverse security bars so that they pass across said attachment flanges of said stile members, and positioning said upright security bars so that they pass across said attachment flanges of said rail members wherein said upright and transverse security bars reside in contact with and are spot welded to said attachment flanges across which they pass.

3. (Twice Amended) A method according to Claim 2 further comprising forming and positioning said attachment flanges in mutually coplanar relationship with each other to reside in a common plane and said step of spot welding is performed to attach said transverse security bars to said attachment flanges of said stile members on one side of said common plane and said step of spot welding is performed to attach said upright security bars to said attachment flanges of said rail members on the opposite side of said common plane.

5 6. (Twice Amended) A method according to Claim 5 further comprising initially cutting spot welding tip access apertures in said flat, sheet metal strip, thereby creating at least one spot welding tip access aperture in said hollow members at each of said corners, and spot welding said pairs of corner securing tabs to said adjacent hollow members by inserting internal spot welding tips into said spot welding tip access apertures so as to contact said corner securing tabs within said adjacent hollow members, bringing external spot welding tips into external contact with said adjacent hollow members and passing electric currents between said internal and said external spot welding tips to spot weld said

hollow members together at each of said corners.

7. (Twice Amended) A method of fabricating a metal security door comprising:
forming four hollow metal door perimeter segment members so as to
define a plurality of security bar receiving openings in each of said perimeter segment
members,

5 positioning a plurality of metal security bars to project through said
security bar receiving openings and into said perimeter segment members so that said ends
of said metal security bars terminate within said perimeter segment members and
positioning said perimeter segment members together to form a rectangle, and
spot welding said ends of said metal security bars to said perimeter
segment members within which they terminate.

8. (Twice Amended) A method according to Claim 7 further comprising roll
forming said segment members so as to create a security bar attachment flange on each of
said hollow perimeter segment members, whereby when said perimeter segment members
are positioned together to form said rectangle said attachment flanges all project inwardly
5 within said rectangle and lie in a common plane, and whereby said security bar receiving
openings in each of said perimeter segment members reside proximate to said security bar
attachment flange thereof on one side of said common plane while said security bar
receiving openings in each adjacent perimeter segment member lie on the opposite side of
said common plane.